

Date: Thursday, 12/20/2007 3:16:15 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : OUTER AFT SADDLE
Job Number : 36461	
Estimate Number : 11080	
P.O. Number :	Part Number : D5955
This Issue : 12/20/2007 S.O. No. :	Drawing Number : D5955 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : 1 / Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 35035	Material :
Written By :	Due Date : 1/12/2008 Qty: 10 Um: Each
Checked & Approved By : <u>07.12.21</u>	
Comment : Est Rev:E Re-Format 05-11-29 JLM	
Est Rev:F ecn826 06.12.06 ec	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101013	Saddle billet
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

D6101-013 (7075-T7351)

Size 2.50" x 10.10" X 8.25" (Grain along 10.10")

Batch: B25060 x 5 / 11 x 25357 / 4 x 31390

SF 08/01/26

2.0	HAAS3	HAAS CNC VERTICAL MACHINING #3
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Comment: HAAS CNC VERTICAL MACHINING #3

1-Machine as per folio D5955, Ensure Batch Number is entered

2-Machine Keyway

3-Deburr & Tumble

SF 08/01/26

3.0	QC1	INSPECT ALL DIM TO DIM SHEET
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Comment: INSPECT ALL DIM TO DIM SHEET

SF 08/01/26 (10)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SD 08/01/28 (10)

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

08-01-29

(10)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: PD Date: 08/01/37
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 12/20/2007 3:16:16 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: OUTER AFT SADDLE

Job Number: 36461

Part Number: D5955

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



M 106379



(10)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

BR 08-01-29

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



HL



(X10)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-01-29

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *421*

8/1/30 SC

(10X)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



(10)

Comment: FINAL INSPECTION/W/O RELEASE

08/01/31

Job Completion



08-01-31

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	36461
Description: Outer Aft Saddle		Part Number:	D5955
Inspection Dwg: D5955	Rev: B	Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443		.441	.441	.441	.441		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	5.245	5.255		5.250	5.250	5.250	5.250		
D	6.995	7.005		7.002	7.000	7.000	7.000		
E	5.745	5.755		5.750	5.750	5.750	5.750		
F	4.745	4.755		4.750	4.750	4.750	4.750		
G	0.315	0.322		.318	.318	.318	.318		
H	1.522	1.532		1.530	1.530	1.530	1.530		
I	3.048	3.058		3.050	3.050	3.050	3.050		
J	4.575	4.585		4.578	4.578	4.578	4.578		
K	0.313	0.318		.318	.318	.318	.318		
L	0.495	0.505		.500	.500	.500	.500		
M	0.490	0.510		.500	.500	.500	.500		
N	1.865	1.885		1.875	1.875	1.875	1.875		
O	7.990	8.010		8.001	8.001	8.001	8.001		
P	2.240	2.260		2.250	2.250	2.250	2.250		
Q	0.307	0.312		.310	.310	.310	.310		
R	0.760	0.765		.760	.760	.760	.760		
S	0.490	0.510		.500	.500	.500	.500		
T	1.625	1.645		1.630	1.630	1.630	1.630		
U	2.000	2.020		2.000	2.000	2.000	2.000		
V	0.023	0.043		.033	.033	.033	.033		
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	RF
Date:	08/01/27

Audited by:	
Date:	

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686	KJ/RF	
C	06.11.20	Added dimension V	KJ/JLM	
D	06.12.06	Dimensions L,N,P revised	KJ/EC	
E	07.06.15	Dimension G revised	KJ/JLM	

DART AEROSPACE LTD		Work Order:	36461
Description: Outer Aft Saddle		Part Number:	D5955
Inspection Dwg: D5955	Rev: B	Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	50	62	73	Y4		
A	0.438	0.443		.441	.441	.441	.441		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	5.245	5.255		5.250	5.250	5.250	5.250		
D	6.995	7.005		7.000	7.000	7.000	7.000		
E	5.745	5.755		5.750	5.750	5.750	5.750		
F	4.745	4.755		4.750	4.750	4.750	4.750		
G	0.315	0.322		.318	.318	.318	.318		
H	1.522	1.532		1.530	1.530	1.530	1.530		
I	3.048	3.058		3.050	3.050	3.050	3.050		
J	4.575	4.585		4.580	4.580	4.580	4.580		
K	0.313	0.318		.318	.318	.318	.318		
L	0.495	0.505		.500	.505	.505	.505		
M	0.490	0.510		.507	.507	.507	.506		
N	1.865	1.885		1.875	1.875	1.875	1.875		
O	7.990	8.010		8.002	8.005	8.002	8.002		
P	2.240	2.260		2.250	2.250	2.250	2.250		
Q	0.307	0.312		.310	.310	.310	.310		
R	0.760	0.765		.760	.760	.760	.760		
S	0.490	0.510		.500	.500	.500	.500		
T	1.625	1.645		1.628	1.628	1.628	1.628		
U	2.000	2.020		2.000	2.000	2.000	2.000		
V	0.023	0.043		.033	.033	.033	.033		
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	RF
Date:	08/01/28

Audited by:	
Date:	

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686	KJ/RF	
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DART AEROSPACE LTD		Work Order:	36461
Description: Outer Aft Saddle		Part Number:	D5955
Inspection Dwg: D5955		Rev: B	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	9	10	3	4		
A	0.438	0.443		.441	.441				
B	1.745	1.755		1.750	1.750				
C	5.245	5.255		5.250	5.250				
D	6.995	7.005		7.000	7.000				
E	5.745	5.755		5.750	5.750				
F	4.745	4.755		4.750	4.750				
G	0.315	0.322		.318	.318				
H	1.522	1.532		1.530	1.530				
I	3.048	3.058		3.050	3.050				
J	4.575	4.585		4.580	4.580				
K	0.313	0.318		.318	.318				
L	0.495	0.505		.500	.500				
M	0.490	0.510		.507	.507				
N	1.865	1.885		1.875	1.875				
O	7.990	8.010		8.000	8.000				
P	2.240	2.260		2.250	2.250				
Q	0.307	0.312		.310	.310				
R	0.760	0.765		.760	.760				
S	0.490	0.510		.500	.500				
T	1.625	1.645		1.635	1.635				
U	2.000	2.020		2.000	2.000				
V	0.023	0.043		.033	.033				
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

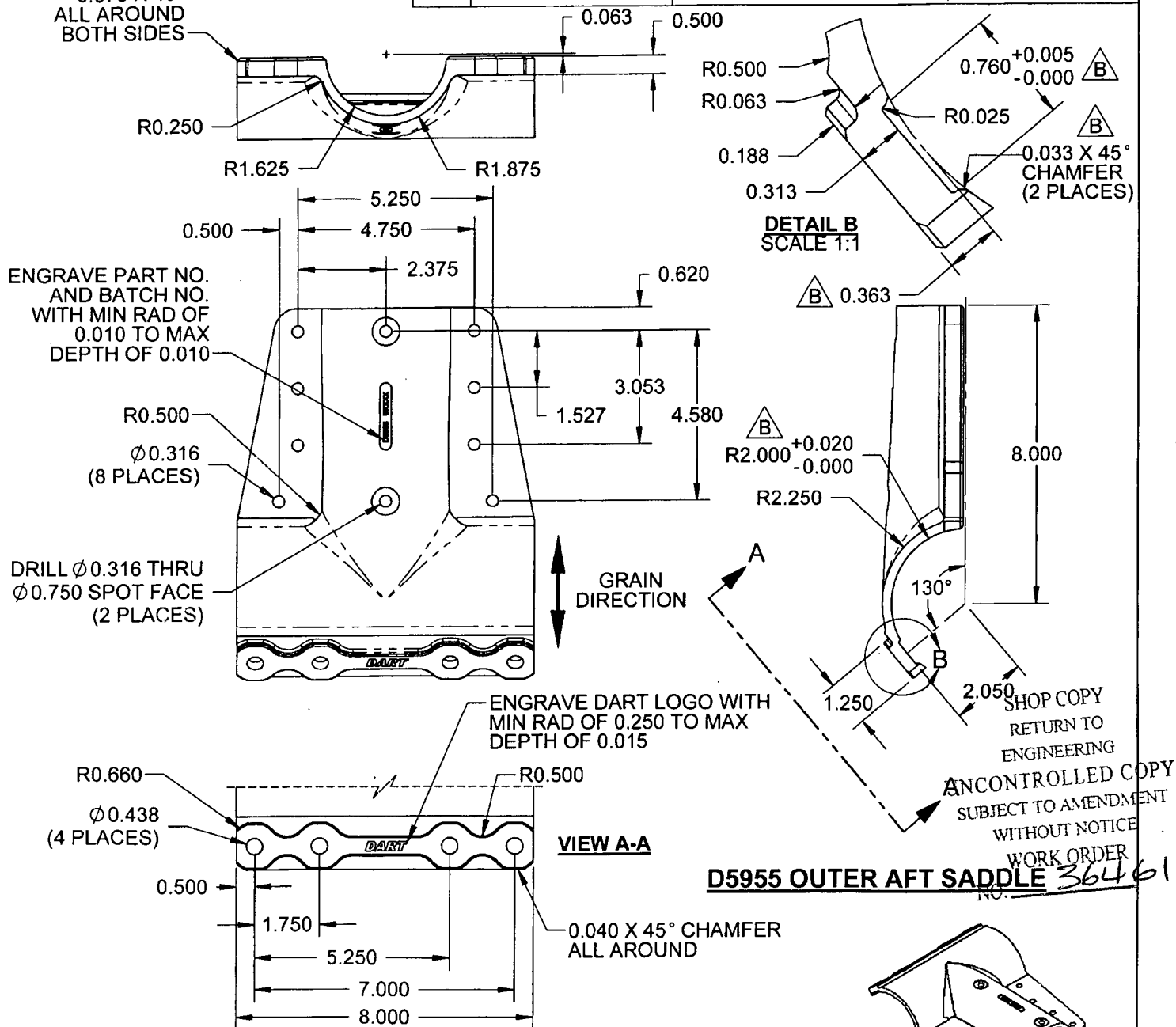
Measured by:	J.B
Date:	05/01/28

Audited by:	
Date:	

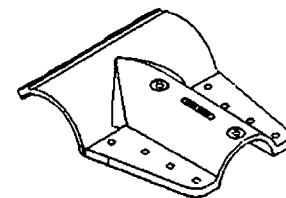
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E	07.06.15	Dimension G revised	KJ/JLM	

DART

DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED LE	APPROVED H	DRAWING NO. D5955
DATE 06.11.07	TITLE OUTER AFT SADDLE	REV. B SHEET 1 OF 1 SCALE 1:4
REV A	DATE 97.05.06	DESCRIPTION NEW ISSUE
B	06.11.07	INCORPORATE DEO 9102, DEO 9079; ADD 0.363 DIMENSION; $\phi 0.316$ WAS $\phi 0.313$; ADD TOLERANCE TO R2.000; ADD 0.363 DIM

**NOTES:**

- 1) MATERIAL: ALUMINUM 7075-T7351 PER QQ-A-250/12
(MAKE FROM D6101-013 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020

**ISOMETRIC VIEW**
SCALE 1:8

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